

Work Order ID 63624

Friday, November 05, 2010 10:24:15 AM



Page 1

Item ID: D3916-041

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly

Stop



Start Date: 11/5/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 11/12/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

M

Date: 10-11-04 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3916	A

100



Large Fab

Memo

0.00

Large Fab

1- Cut tube 50"

2- Bend tube with manuel pipe bender as per DT9567

*** Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending***

3- Trim access tube material to finish size as per dwg D3916

4- Drill and chamfer holes as per dwg D3916-1 using DT9605

5- weld bushing as per dwg D3916

6- grind welds flush

110



QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

0.00

Solvubts

X6

S90 10-11-17

CPL 10-11-24

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC10- Inspect visual per QSI004- ground welds

0.00

10/16/25

QC

Quality Control

130



Identify as per dwg & Stock Location:

0.00

10/16/25

SP

Packaging

Packaging

140



QC21- Final Inspection - Work Order Release

0.00

10/16/25

QC

Quality Control

Memo

0.00

10/16/25

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Picklist Print

Friday, November 05, 2010 10:24:29 AM

Page 1

Work Order ID: 63624



Parent Item: D3916-041



Parent Item Name: Rib Assembly

Start Date: 11/5/2010

Required Date: 11/12/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: New issue DD verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3759-1 		Manufactured	No			100	Each	40.0000	7 	42 <i>CPL 10-11-24</i>			
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Bushing

Location	Loc Qty	Loc Code
ST084	21	
56942	21	
WA	19	
- 54072	9	
- 61379	10	

B63875 → 11/6/14

M304TS0.750W.049 		Purchased	No			100	f	298.6790	4.166 	26.31158 <i>SAD 10-11-17</i>			
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304 SQ Tube .75x.75x.049W

Location	Loc Qty	Loc Code
MAT	33.97876794	
113763	0	
114323	20.0582189	
114677	7.69741	
114835	6.223139	
MAT017	3.68448E-05	
114298	3.6845E-05	
WA	264.7002	
114992	33.7547	
115260	230.9455	

26.3116

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8 7 6 5 4 3 2 1

D

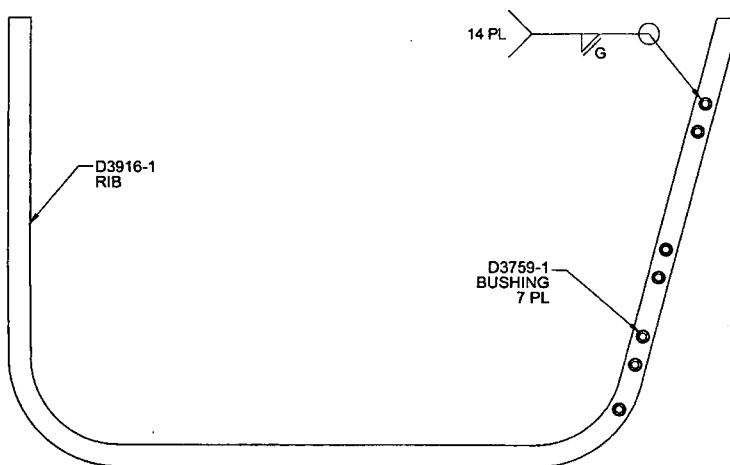
D

C

C

B

B



D3916-041 RIB ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 63624
2/10-11-05

RELEASED
2010-03-12
MP

A NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -041: 1.84 lbs
- 8) WELD PER DART QSI 004

8 7 6 5 4 3 2 1

DESIGN	AJS	DART AEROSPACE LTD
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>99</i>	DRAWING NO. REV. A
MFG. APPR.	<i>E</i>	D3916 SHEET 2 OF 4
APPROVED	<i>M</i>	TITLE
DE APPR.	<i>M</i>	SCALE
DATE	10.03.04	RIB ASSY, 350 BASKET NTS

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8 7 6 5 4 3 2 1

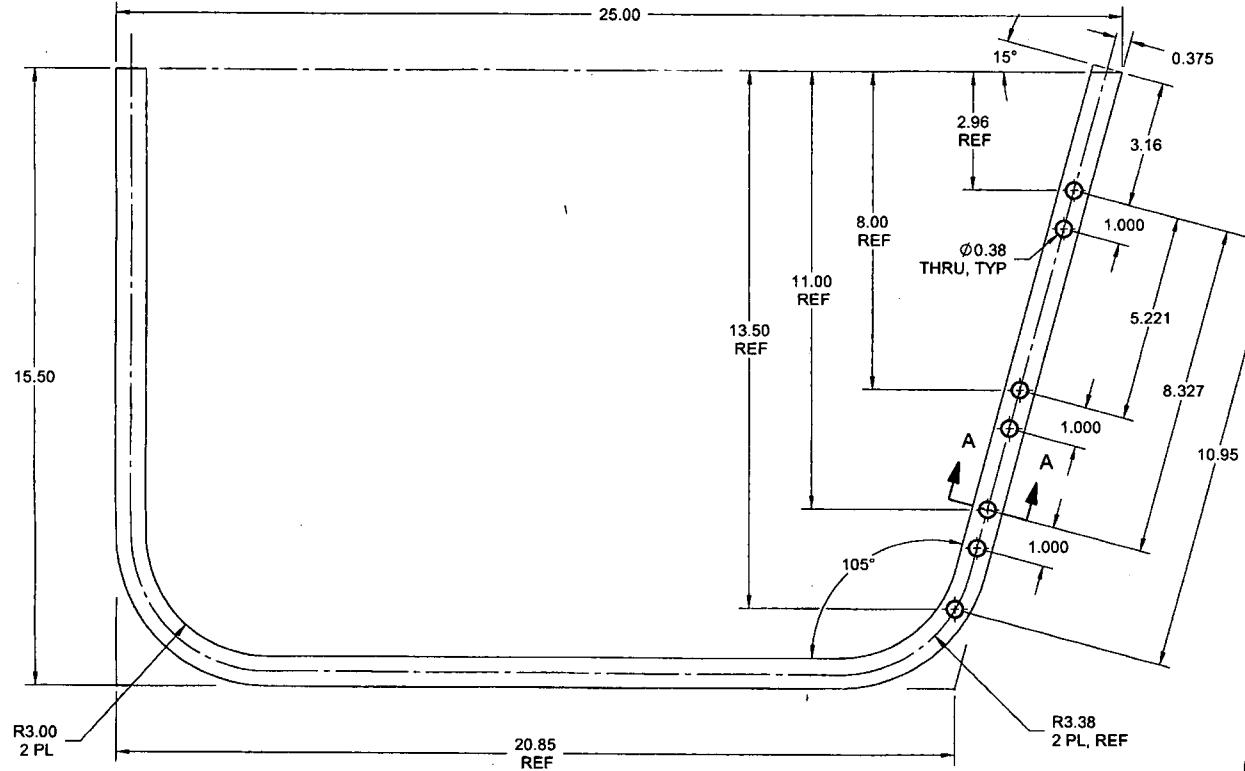
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9 D3916-1 RIB

1043424

RELEASED
2010-03-12

NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.75W0.049

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 1.76 lbs

9) TUBE FLAT LENGTH 50.0 REF

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	99	DRAWING NO.	REV. A
MFG. APPR.	ES	D3916	SHEET 3 OF
APPROVED	NA	TITLE	SCALE
DE APPR.	**	RIB ASSY, 350 BASKET	NTS
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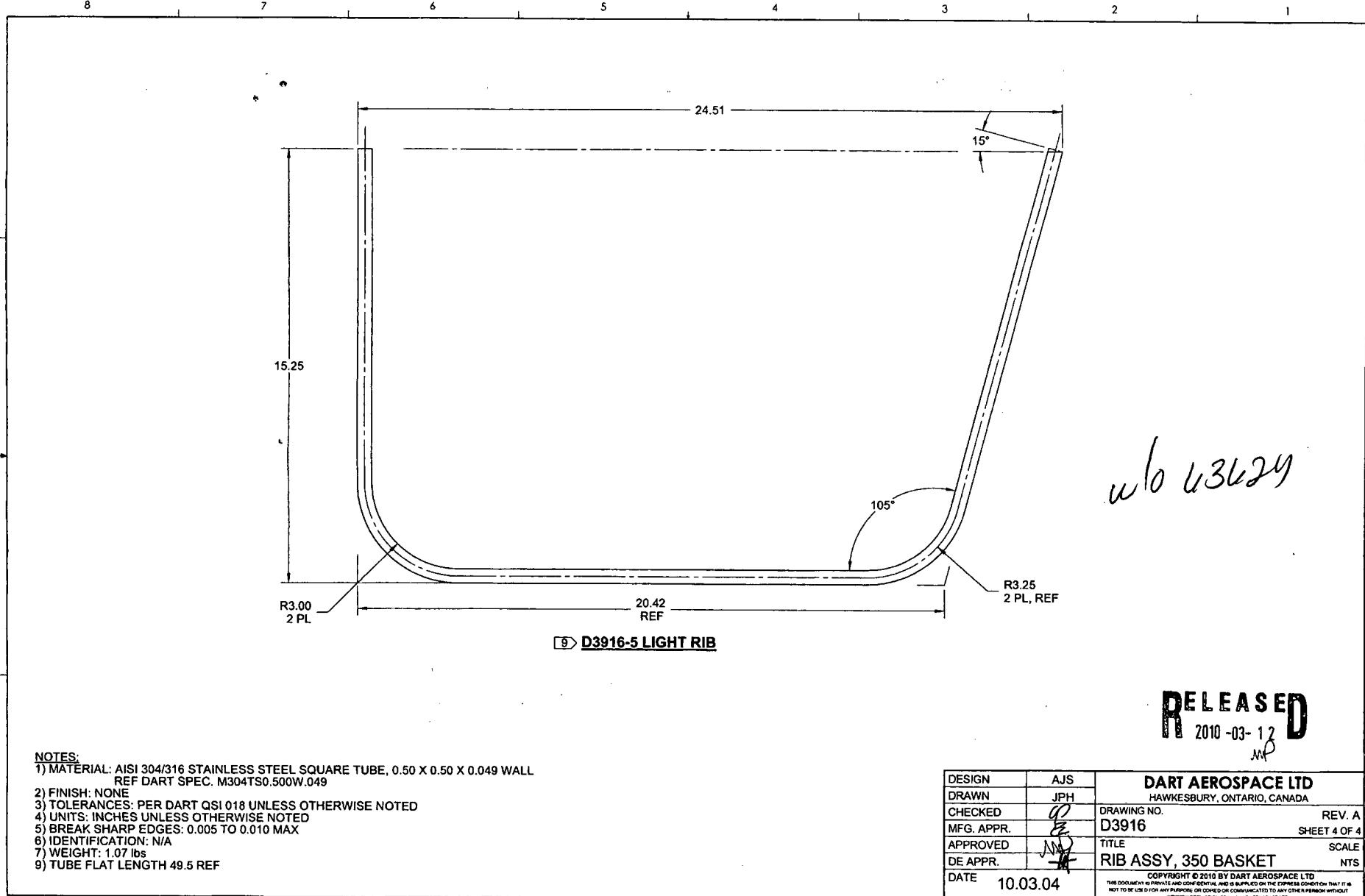
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